



MODEL T25554/T25555 EXTENSION BLOCK KIT INSTRUCTIONS

For questions or help with this product contact Tech Support at (570) 546-9663 or techsupport@grizzly.com

Introduction

This Extension Block Kit increases the maximum cutting height of the Model G0555LX/G0555LANV 14" bandsaw from 6" to 12".

The T25554 matches the black color scheme of the G0555LANV. The T25555 matches the green color scheme of the G0555LX.

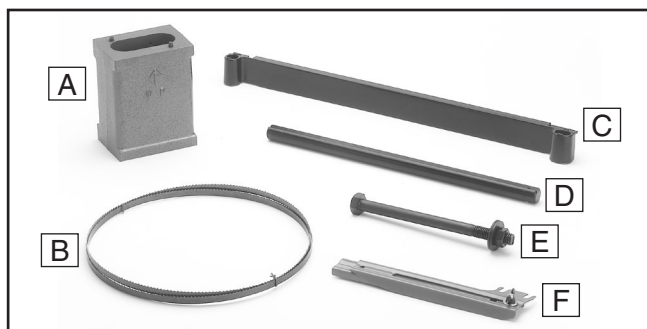


Figure 1. T25555 Extension Block Kit.

Inventory

Description	Qty
A. Extension Block.....	1
B. Saw Blade 105".....	1
C. Extended Saw Blade Guard.....	1
D. Extended Guide Post.....	1
E. Hardware	
—Hex Bolt 5/8"-11 x 8-1/2	1
—Hex Nut 5/8"-11.....	1
—5/8" Flat Washer.....	2
—Cord Clamp ACC-3 (not shown).....	1
—Phillips Hd Scr 10-24 x 1/2" (not shown)..	1
F. Extended Blade Guard Assembly.....	1

Items Needed

Items Needed	Qty
Adjustable Wrenches	2
Phillips Screwdriver #2.....	1
Hex Wrench 5mm and 3mm	1 Each
Another Person for Assistance.....	1

Cleanup

The unpainted surfaces of the extension block are coated with a heavy-duty rust preventative that prevents corrosion during shipment and storage.

Complete removal of the rust preventative is necessary for the extension block and upper arm to fit properly and be accurately positioned.

Before cleaning, gather the following:

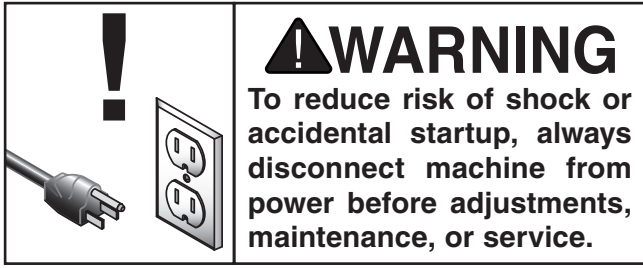
- Disposable Rags
- Cleaner/degreaser (WD-40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

Basic steps for removing rust preventative:

1. Put on safety glasses.
2. Apply a liberal amount of cleaner/degreaser on the rust preventative, then let it soak for 5–10 minutes.
3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with the rag.
4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.

NOTICE

Avoid chlorine-based solvents, such as acetone or brake parts cleaner, that may damage painted surfaces.



Installing Riser Block

1. DISCONNECT BANDSAW FROM POWER!
2. Remove bandsaw blade (refer to the Owner's Manual included with your bandsaw). When finished, leave the wheel covers open.
3. Remove the left-side blade guard (**Figure 2**). It is held in place with one screw at the top and one at the bottom.

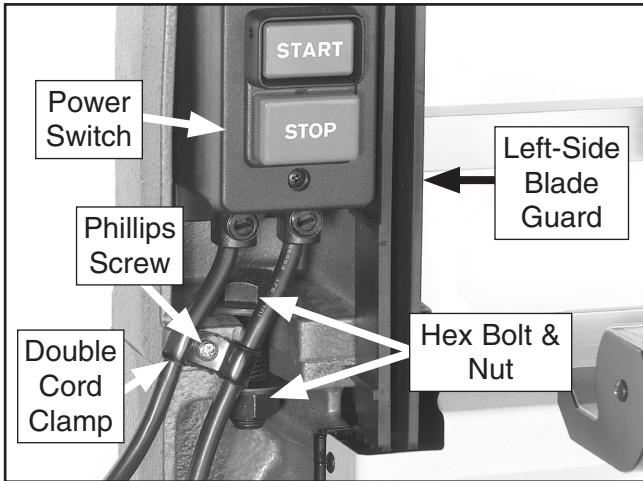


Figure 2. Components surrounding riser block.

4. Taking care not to disconnect any wiring, remove the power switch and the double cord clamp (**Figure 2**). Let the switch hang to the side for now.

Note: The switch is fastened in place with one screw **above** the box and one **below** it. Avoid removing the two screws on the face of the switch box, as this will open the switch box cover, exposing the wiring inside.

5. Remove the hex nut and bolt shown in **Figure 2**. With help from another person, lift the upper arm off the base casting.

IMPORTANT: Make sure all mating surfaces of riser block are clean before proceeding.

6. Install the riser block and replace the upper arm, as shown in **Figure 3**, using (1) $\frac{5}{8}$ "-11 x $8\frac{1}{2}$ " hex bolt, (2) $\frac{5}{8}$ " flat washers, and (1) $\frac{5}{8}$ "-11 hex nut.

Note: Make sure the arrow on the riser block points up and faces behind the machine. Also, make sure alignment pins fit completely into holes during installation.

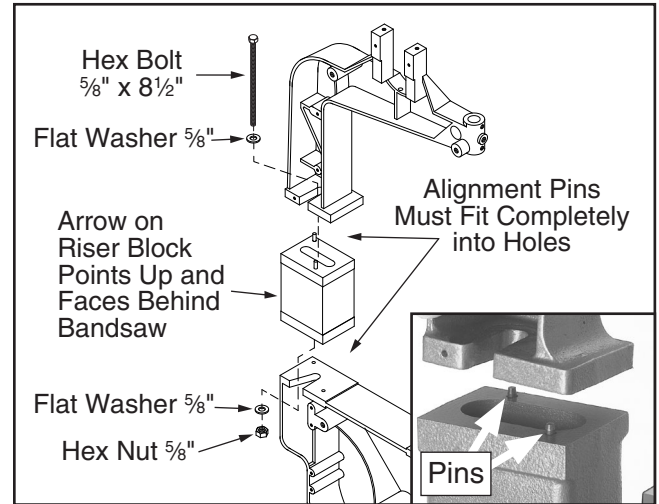


Figure 3. Installing riser block.

7. Install the extended left-side blade guard, using the screws removed in **Step 3**.
8. Raise the upper guide assembly all the way up, then tighten the lock knob (**Figure 4**).

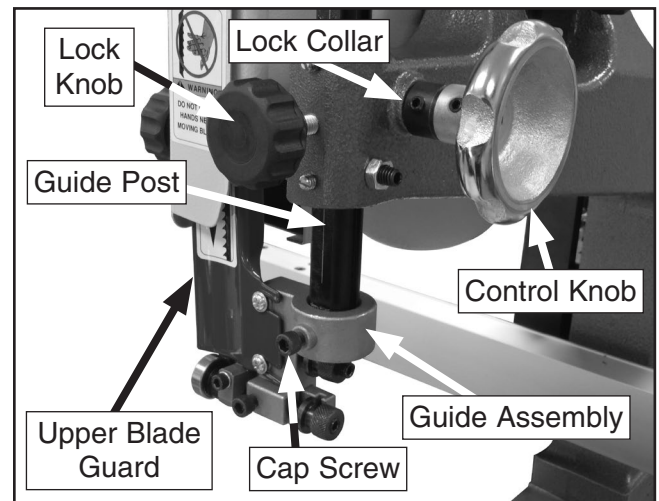


Figure 4. Upper blade guard and nearby components/controls.

9. Loosen the cap screw (**Figure 4**), and disconnect the guide assembly from the guide post, then remove the guide assembly and upper blade guard.



10. Remove the guide post control knob and lock collar (**Figure 4**) from the pinion gear shaft.
11. Push the pinion gear shaft inward to disengage the gear from the rack (see **Figure 5**).

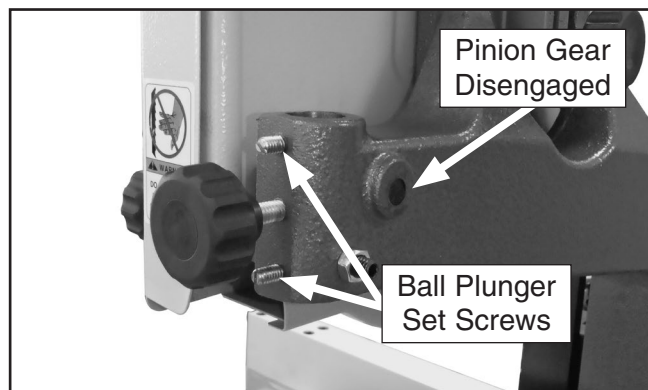


Figure 5. Pinion gear shaft pushed in.

12. Unthread the two ball plunger set screws (**Figure 5**) away from the guide post. (It is not necessary to remove them.)
13. Hold the guide post with one hand, then loosen the lock knob with the other hand and slide guide post up and out of its housing.
14. Insert the extended guide post into the housing, as shown in **Figure 6**, making sure the keyway is aligned with the set screw.

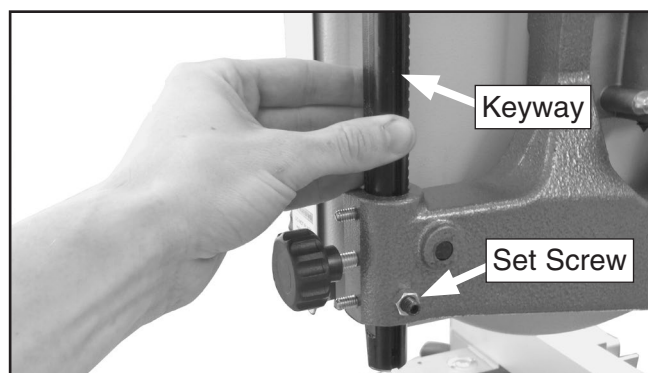


Figure 6. Installing extended guide post.

15. Slide the pinion gear away from the saw and ensure the gear teeth engage the guide post rack.
16. Thread the ball plunger set screws back into place—but avoid over-tightening them. At the proper setting, the guide post should move up and down by hand, but remain stationary when the lock knob is released.

17. Replace the lock collar and guide post control knob.
18. Attach the guide assembly and the extended blade guard to the guide post.
19. Attach the cord clamp using (1) 10-24 x 1/2" Phillips head screw (see **Figure 7**), and replace the power switch assembly and double cord clamp removed in **Step 4**.

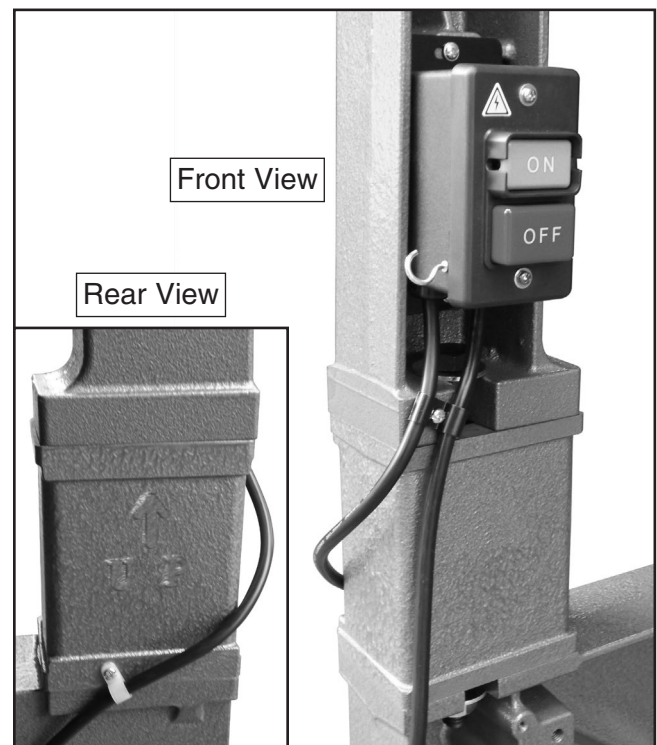


Figure 7. Extension block installed.

20. Install the 105" bandsaw blade, and without starting the saw, tension the blade approximately where it should be for a regular cutting operation.

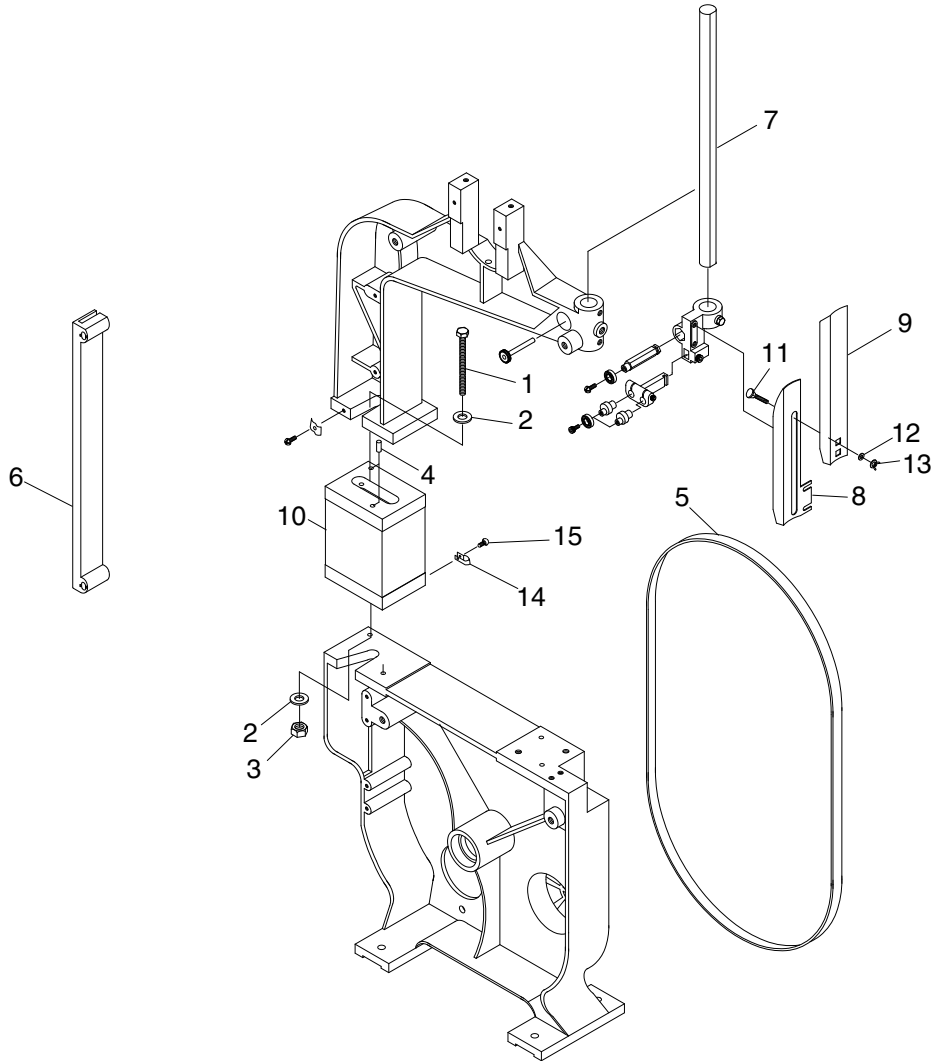
—If you have difficulty setting the tension on the 105" blade, the tensioning mechanism on the bandsaw may need to be re-adjusted to accommodate the new blade length. Follow the **Blade Tensioner** instructions in the G0555LX Owner's Manual.

21. Align the bandsaw wheels so they are coplaner. Refer to **Wheel Alignment** procedure in the G0555LX Owner's Manual.

Congratulations! The riser block installation procedure is now complete.



Riser Block Parts Breakdown



T25554 Parts List

REF	PART #	DESCRIPTION
1	PB120	HEX BOLT 5/8-11 X 8-1/2
2	PW14	FLAT WASHER 5/8
3	PN04	HEX NUT 5/8-11
4	PT25555004	SOLID PIN 6 X 15
5	PT25555005	SAW BLADE 6 TPI X 105 X 3/8
6	PT25555006	LEFT-SIDE BLADE GUARD
7	PT25555007	EXTENDED GUIDE POST
8	PT25554008	EXTENDED BLADE GUARD (ORANGE)
9	PT25554009	BLADE GUARD (ORANGE)
10	PT25554010	EXTENSION BLOCK (BLACK)
11	PCB02	CARRIAGE BOLT 5/16-18 X 1/2
12	PW07	FLAT WASHER 5/16
13	PWN03	WING NUT 5/16-18
14	PT25555014	CORD CLAMP ACC-3
15	PS01	PHLP HD SCR 10-24 X 1/2

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5	PT25555005	SAW BLADE 6 TPI X 105 X 3/8
6	PT25555006	LEFT-SIDE BLADE GUARD
7	PT25555007	EXTENDED GUIDE POST
8	PT25555008	EXTENDED BLADE GUARD (RED)
9	PT25555009	BLADE GUARD (RED)
10	PT25555010	EXTENSION BLOCK (GREEN)
11	PCB02	CARRIAGE BOLT 5/16-18 X 1/2
12	PW07	FLAT WASHER 5/16
13	PWN03	WING NUT 5/16-18
14	PT25555014	CORD CLAMP ACC-3
15	PS01	PHLP HD SCR 10-24 X 1/2

Parts breakdown provided for reference only. Not all parts shown are available for purchase.

